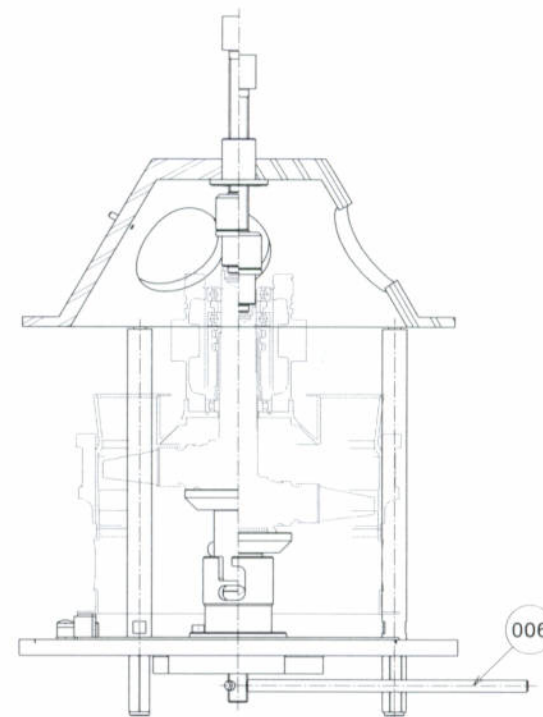
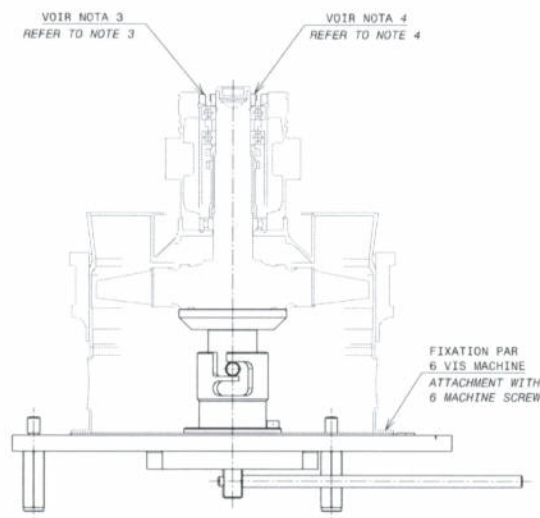
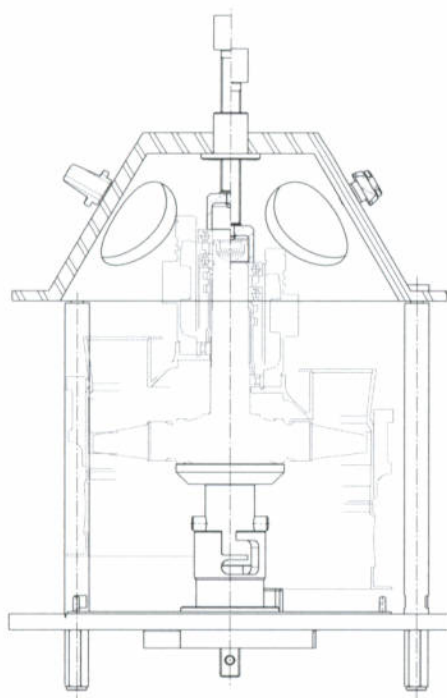


1er OPERATION :
EMMANCHMENT DE LA TL
1st OPERATION :
COUPLING TL

2eme OPERATION :
POSITION SERRAGE ET DESSERAGE
2nd OPERATION :
TIGHTENING AND SLACKENING POSITION

3eme OPERATION :
EXTRACTION DE LA T.L
3rd OPERATION :
TL EXTRACTION



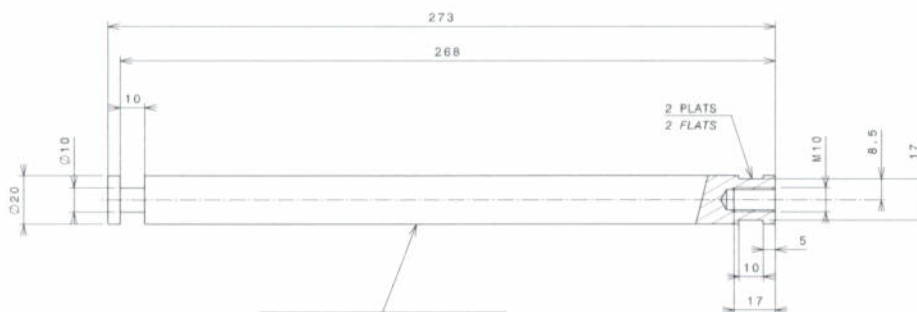
DESIGNED BY: MICHAEL 10/11/05		APPROVED BY: MICHAEL 10/11/05		INTERPRETATION DES DESSINS SELON INTERPRETATION OF DRAWINGS AS PER: ST2100	
MACHINE : F50100	DESIGNATION PRECISE : 1001 DESCRIPTION 1001 DESCRIPTION	N° PIÉCE / PART NUMBER 70 00 04 104 D			
DESIGNATION OUTILAGE					
MONTAGE EMMANCHEMENT					
TOOL NAME					
FREE TURBINE INSTALL & REMOVAL					
CE DESSIN EST LA PROPRIÉTÉ DE LA SOCIÉTÉ TURBOMÉCA. IL NE PEUT ÊTRE COMMUNIQUÉ OU REPRODUIT SANS SON AUTORISATION THIS DRAWING IS THE PROPERTY OF TM AND MAY NOT BE COPIED OR COMMUNICATED WITHOUT EXPRESS AUTHORIZATION					
Echelle SCALE 1/1		Turbomeca Groupe SAFARI		CODE FABRICANT P2001 MANUFACTURER CODE	
FORMAT ST21 A1		881 9 578 000		PLANCHE SHEET 2	

VIS	35 NCD 16	ORIGINAL	RECHT/NIJ	SCHEP	BEPS
	1400-1600 MPa	32	✓	1/1	24/04/95
SCREW	-	881 9 578 011			INHOUD 1 MOEDER

Plan Dessiné à l'aide du logiciel CATIA V5 Drawing drawn with CATIA V5 software	MACHINE : FROSTAT	VS DESIGNATION PRECIS : PART JOINTURE	VS PRECIS : PART JOINTURE
	BARRELL 1	MOULES TURBINE LOIRE	70 BM 64 104 D
DESIGNATION OUTILAGE			
MONTAGE EMMANCHEMENT			
TOOL NAME			
FREE TURBINE INSTALL & REMOVAL			
CE DESIGNE L'APPARTENANCE DE LA SOCIETE TURBOMECA & NE PEUT ETRE COMMUNIQUE OU REPRODUIT SANS SON AUTORISATION THIS DRAWING IS THE PROPERTY OF TW AND MAY NOT BE COPIED OR COMMUNICATED WITHOUT EXPRESS AUTHORIZATION			
ECHELLE SCALE	 Turbomeca Groupe LOIRETTE		CODE FABRIANT FOUR- NANT FOURN : 000
 FORMAT SIZE A1	881 9 578 000		PLANCHE SHEET 3



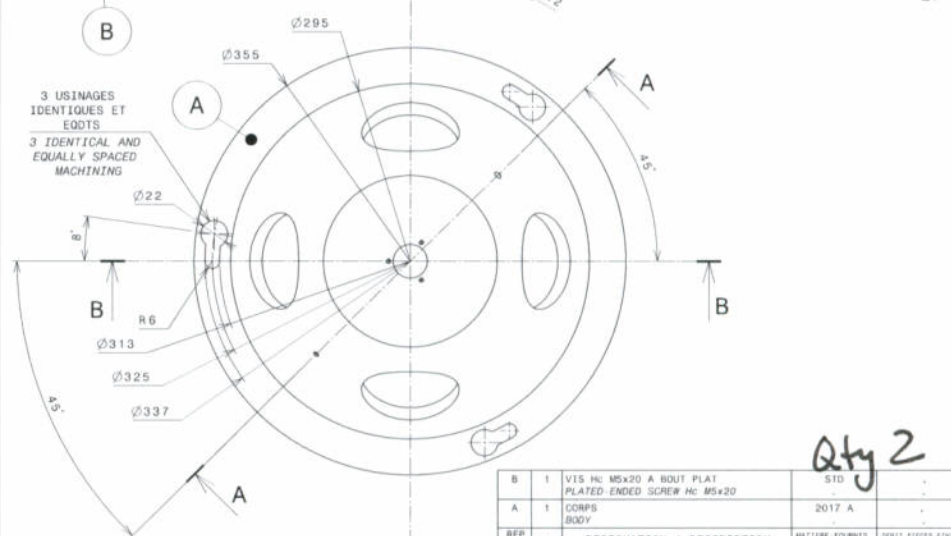
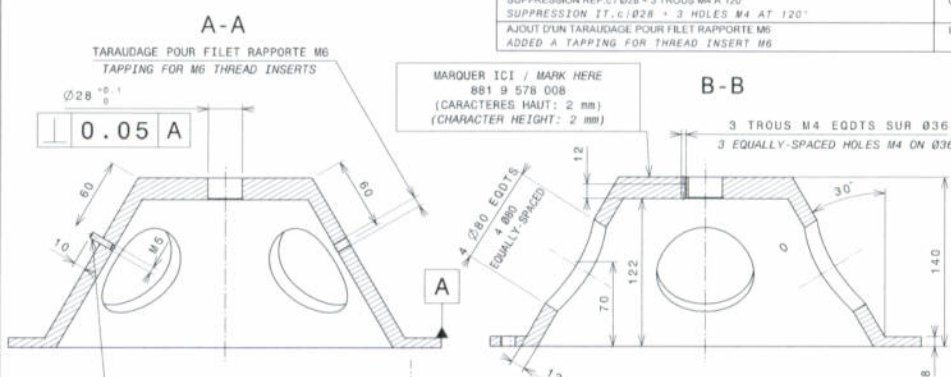
POUSOIR	LIE B P	DATE / MONTH / YEAR 10 / 11 / 2010	SCHEELE SCALE 1/1	DEPS
PLUNGER		881 9 578 009		IMP END



MARQUER ICI / MARK HERE
881 9 578 007
(CARACTERES HAUT: 2 mm)
(CHARACTER HEIGHT: 2 mm)

PROTECTION : BRUNISSAGE (TYPE PENTRATE)
PROTECTION : BURNISHING (PENTRATE TYPE)

COLONNE	25 CD 4	0.01 MPa / MACHINING 	SCHELLS SCALE 1/1	DEPS 24/04/95
	300 - 1050 MPa			
COLUMN	-	881 9 578 007		IND (M)



PROTECTION : ANODISATION NOIRE POUR REP.A
PROTECTION : BLACK ANODIZING FOR IT.A
LE REP.B SERA VISSE COLLE A LA LOCTITE FREIN FILET FORT
THE IT.B WILL BE SCREWED BONDED WITH
HIGH THREAD LOCK LOCTITE SEALANT

B	1	VIS Hc M5x20 A BOUT PLAT PLATED ENDED SCREW Hc M5x20	SD	
A	1	CORPS BODY	2017 A	
REP ITEM	QUANT	DESIGNATION / DESCRIPTION	MATIERE FOURNIE MATERIAL SUPPLIER	DEBIT PEGEES FIN FIN FINISHED MA

CLOCHE	ENS. VISSE	MEINAGE / BACKENING	ECHILLE SCALE	SEPS
	VOIR TABLEAU	5.9 ✓	1/2	24049
SHROUD	SCREWED ASS.	881 9 578 008		[N] [M]
	REFER TO TABLE			

DESIGNER DRAWN BY: MECAPRECIS C. C. LOUANGE	VIEWER APPROVED BY: MESPLEDE	INTERPRETATION OF DESIGNS SECTION INTERPRETATION OF DRAWINGS AS PER: ST2100
--	------------------------------------	---

LE: 100110		
MACHINE: FWG 12	DESIGNATION PRICE / PART DESCRIPTION	N° PIECE / PART NUMBER
ARMILL 1	MODULE TURBINE LÈVE	70 RM 04 104 0
	PIÈCE TURBINE MODULE	

DESIGNATION CATTLE AGE

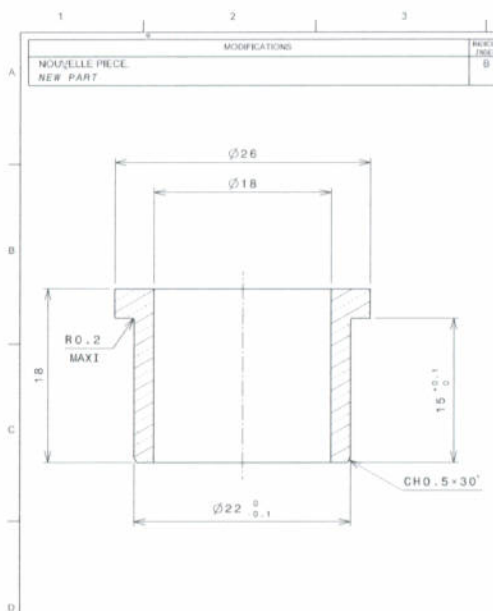
MONTAGE EMMANCHEMENT

TOOL NAME
FREE TURBINE INSTALL & REMOVAL

CE DESSIN EST LA PROPRIETE DE LA SOCIETE TURBOMECA. IL NE
PEUT ETRE COMMUNIQUE OU REPRODUIT SANS SON AUTORISATION
THIS DRAWING IS THE PROPERTY OF TM AND MAY NOT BE COPIED OR
COMMUNICATED WITHOUT EXPRESS AUTHORIZATION

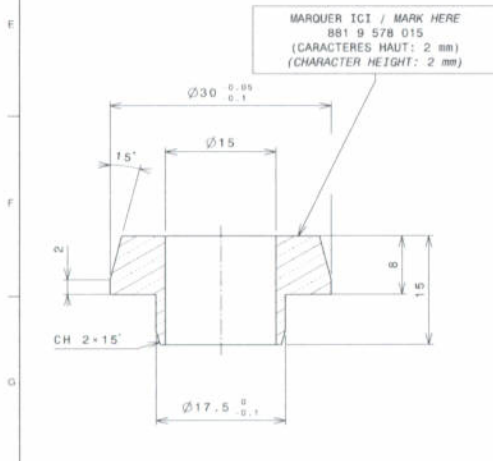
ECHELLE SCALE	 Turbomeca Groupe SAFRAN	CODE FABRICANT F022 MANUFACTURER CODE
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	FORMAT SIZE A1	881 9 578 000	PLANS SHEET 4
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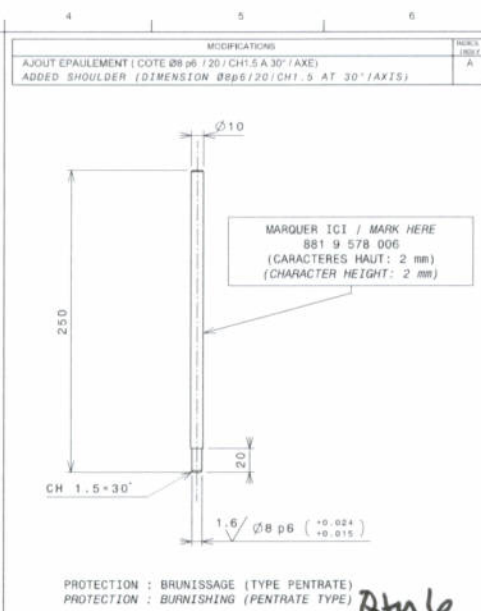


DOUILLE	USE P	DESIGN / MARKING	SCHEM SCALE	SEPS
BUSH		881 9 578 017	2/1	2404/95

MODIFICATIONS	REVISI INDEX E
COTE 18 PASSE A 15 ET Ø18.3 A Ø17.5 DIMENSION 18 BECOMES 15 AND Ø18.3 BECOMES Ø17.5	

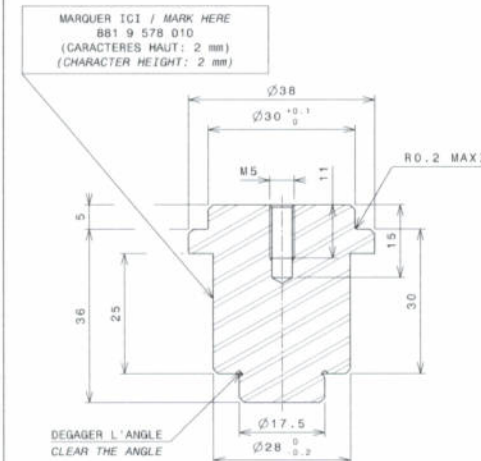


CENTREUR	USE P	DESIGN / MARKING	SCHEM SCALE	SEPS
CENTERING DEVICE		881 9 578 015	2/1	2404/95

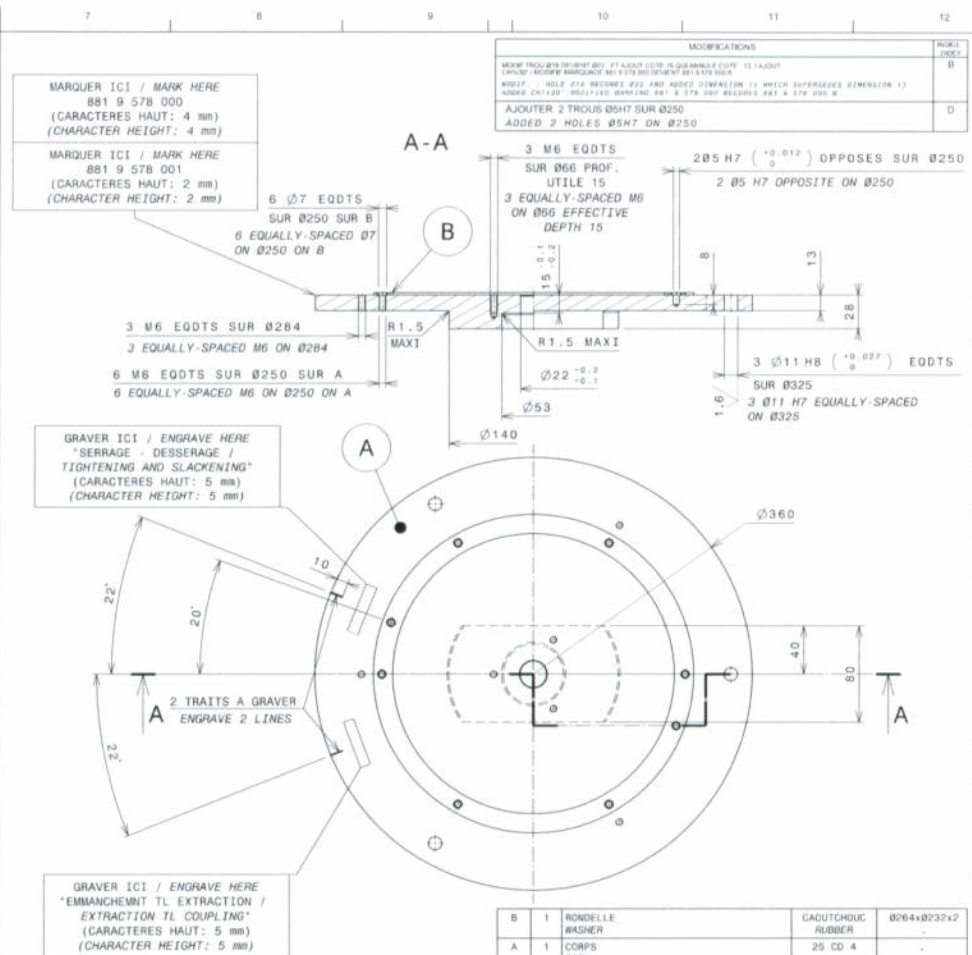


LEVIER	STUB	USE P	DESIGN / MARKING	SCHEM SCALE	SEPS
LEVER			881 9 578 006	1/1	2404/95

MODIFICATIONS	REVISI INDEX A
AJOUT USAGE CENTRAGE (Ø30/51R 0.2 MAX) ADDED CENTERING PIN MACHINING (Ø30/51R 0.2 MAX)	



CIMBLOT	2017 A	USE P	DESIGN / MARKING	SCHEM SCALE	SEPS
CENTERING PIECE			881 9 578 010	2/1	2404/95



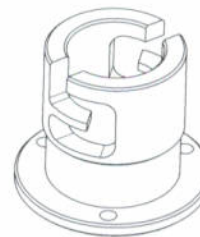
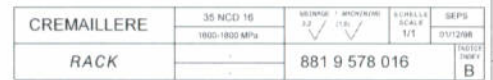
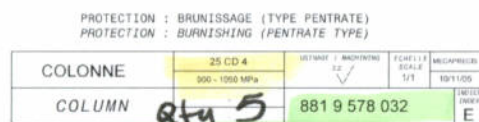
REP	QUANT	DESIGNATION / DESCRIPTION	MATIERE FOURNIE MATERIAL SUPPLIED	REMARKS / REMARQUES
B	1	RONDELLE WASHER	CAOUTCHOUC RUBBER	Ø264xØ232x2
A	1	CORPS BODY	25 CD 4	

PLATEAU	ENS. COLLE	DESIGN / MARKING	SCHEM SCALE	SEPS
PLATE	BONDED ASS.	881 9 578 001	1/1	2404/95

DESIGN / MARKING	USE P	DESIGN / MARKING	SCHEM SCALE	SEPS
881 9 578 001			1/1	2404/95

DESIGNATION OUTILAGE	TOOL NAME
MONTAGE EMMANCHEMENT	FREE TURBINE INSTALL & REMOVAL

SCHEM SCALE	FORMAT SIZE	881 9 578 000	PLANCHE SHEET
2/1	A1		5



FICHE ARTICLE / Product data sheet**(F0228)****8819578000****Version F****MTGE EMMAMCH ET IMMOBILI**

Version GEODE de l'Article / <i>Geode Part Version</i> :	F Engineering
Désignation anglaise / <i>English designation</i> :	FITTING FIXTURE
Type d'article / <i>Item type</i> :	Outillage de production - conception TM
Unité / <i>Unit</i> :	pièce
Article de configuration / <i>Configuration article</i> :	Non
Sujet à péremption / <i>Subject to cure date</i> :	Non
Type de composition / <i>Assembly type</i> :	Composant
Classification / <i>Classification</i> :	Catégorie 3 groupe 2
Masse (kg) / <i>weight (kg)</i> :	20.0
Durée limite de stockage (jours) / <i>Storage limit (days)</i> :	-1

DOCUMENTS DE REFERENCE / Reference documents**ARTICLE DEFINI SELON LE DOCUMENT ST_02100 : Normes, d'application obligatoire pour l' interprétation des dessins TURBOMECA**